

Date: Wednesday, 11/21/2007 12:47:47 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAP
Job Number : 35920	
Estimate Number : 10519	
P.O. Number :	Part Number : D2855
This Issue : 11/21/2007 S.O. No. :	Drawing Number : D2855 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 35663	Material :
Written By :	Due Date : 1/15/2008 Qty: 12 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: B'00.06.22 Added receiving step & removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5113

C20711123 12

Cast per Dwg D2855

Material Release Note Required

2.0	D2855P	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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-Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

7/12/12 sd 12

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5 11/21/13 (x12) counts

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr

FF 07-12-14 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 35920

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/12/14 (X12)

7.0

POWDER COATING

POWDER COATING



M102.316



(12X)

Comment: POWDER COATING



Powder Coat **SANDTEX GREEN**
(Ref: 4.3.5.1) as per QSI 005 4.3



M-1

07/12/17

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07-12-12

(12X)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 ALS7-1032-225

Insert

M100489 *

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

07-12-17

(12X)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/17 (X12)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-22

07-12-17

07-12-17

(12X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 35920

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi 2007/12/18

U

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

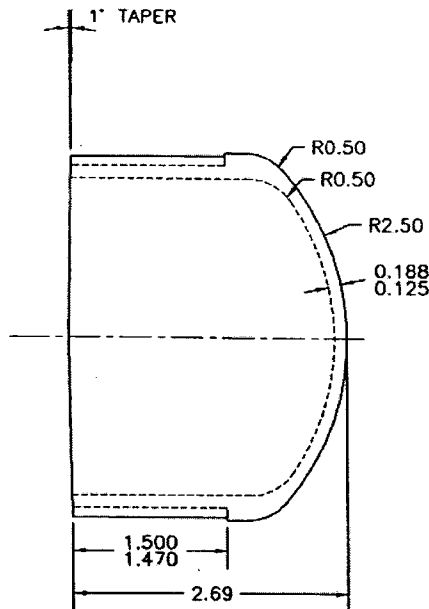
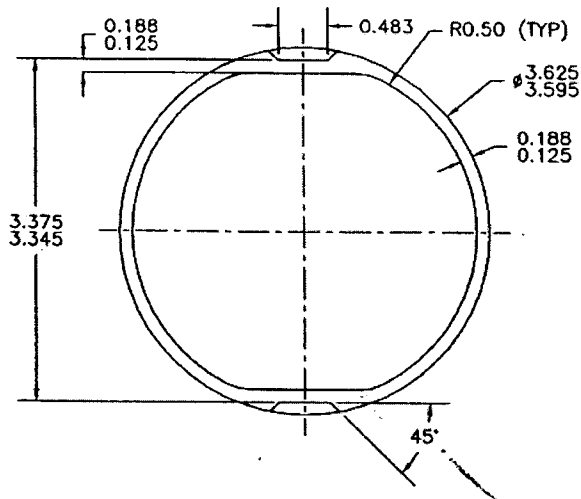
NOTE: Date & initial all entries



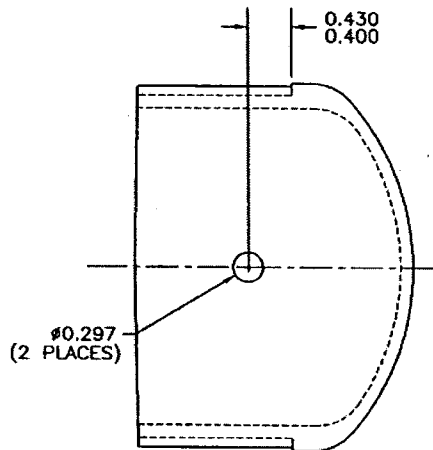
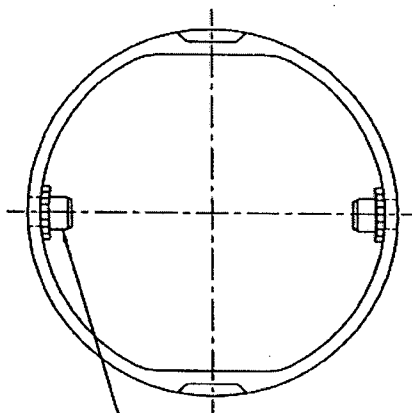
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE		D2855	SHEET 1 OF 1
98.12.12		CAP	SCALE
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)	NTS

RELEASED
98.12.14 DS

D2855 CASTING DETAIL



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

13 KF 99.04.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35920

Aluminum Foundry Ltd

714-716 Calais
Dorval, Québec H9P 2P3
Tel: (514) 631-1331
Fax: (514) 631-8448
email: info@foundryafpw.com

Packing Slip

Packing Slip No.: 32338
Shipped Date: Dec 10, 2007

Sold to:		Ship to:	
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-3336 Fax (613) 632-4443		DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	
Order No.: 5113			
Shipped By: PUROLATOR			
Tracking No.:			

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	30
<div>Received by:</div> <div>Date:</div>			
Comment:			

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448Expédié à
Shipped**DART AEROSPACE**

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing

Date: **013/12/2007** Slip No. **32337****Hawksbury, ON, K6A 1K7**Vôtre No. Commande **5037, 5113**

Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
70	D 2855 CAP	Z098046	A356.2	ingot#850156 /
30	D 2965 CAP	Z200080	A356.2	ingot#850156

Analyse
Analysis (as in Ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.06%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.40%		
(Zn)	<0.01%		
(Ti)	0.18%		

Donne
Yield :Résistance a la tension :
Tensile Strength :Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :
Par/Per :

Coc-100